

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008726**Date Inspected:** 23-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG segments**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG assembly bay 13

This QA observed ZPMC qualified welding personnel identified as 051359 perform SMAW welding on OBG segment 8CW weld joint identified as SEG047H-065. ZPMC QC identified as Mr. Guo Xing Hui was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 058551 perform FCAW welding on OBG segment 9CE weld joint identified as DP313-001-036. ZPMC QC identified as Mr. Guo Xing Hui was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133-Tc-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 055564 perform FCAW welding on OBG segment 9CE weld joint identified as DP313-001-027. ZPMC QC identified as Mr. Guo Xing Hui was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133-Tc-U4b-F.

OBG assembly bay 14

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This QA observed ZPMC qualified welding personnel identified as 050323 perform SAW welding on OBG segment 10CW weld joint identified as SEG063A-019. ZPMC QC identified as Mr. Li Ming Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA observed ZPMC qualified welding personnel identified as 044795 perform FCAW welding on OBG segment 9CE weld joint identified as SEG054C-006 and 019. ZPMC QC identified as Mr. Zhang Guo Hui was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 204730 perform FCAW welding on OBG segment 9DW weld joint identified as CSD2-PP80.5-017. ZPMC QC identified as Mr. Li Ming Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA observed ZPMC qualified welding personnel identified as 045240 perform FCAW welding on OBG segment 10AW weld joint identified as CA071-004. ZPMC QC identified as Mr. Li Ming Yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

Outside OBG segments 7DW, 7BW, 7EW, 6AW, 6CW, 6CE, 7EE and 7DE

This QA observed that no significant work was being performed on these segments during the time QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
